



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3204-00-1

Job Sheet 194603



Part No: RBE350A93-3204-00-1

Job Qty: 2 pcs *3 pcs*

Part Name: Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/6/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3204-00 Rev 0 IPP Rev. A 19.05.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	NLX 2500SY - 1	2 pcs	6/14/19	6/14/19	0.00	2.67	NLX 2500SY - 1		<i>[Signature]</i>
110	QC 2	2 pcs	6/14/19	6/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		<i>[Signature]</i>
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S189482



Part: RBE350A93-3204-00-1

Job No: 194603

Serial No/Batch: S189482

Revision: 0

Inspector:

Exp Date:

Instructions:

Date: 06/12/19

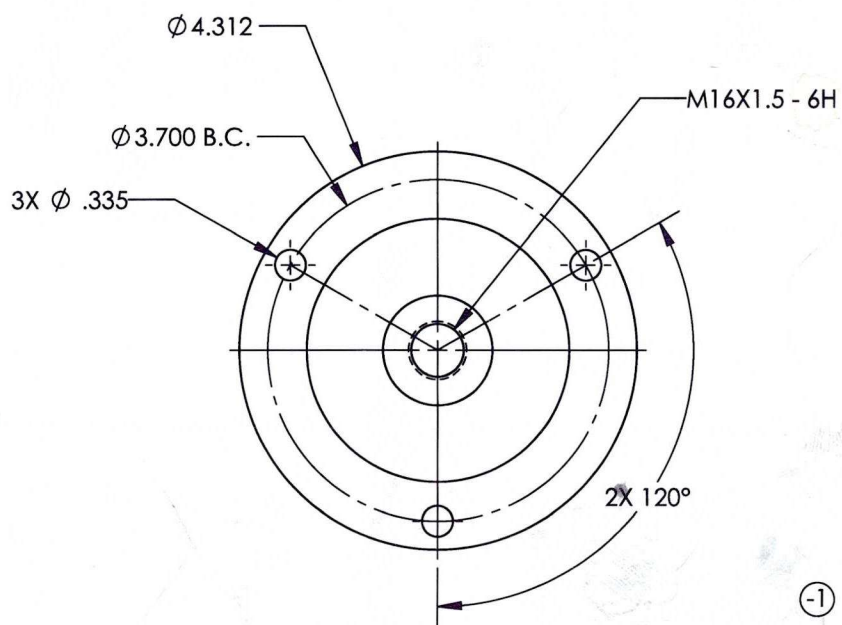
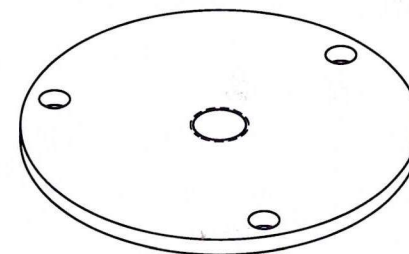
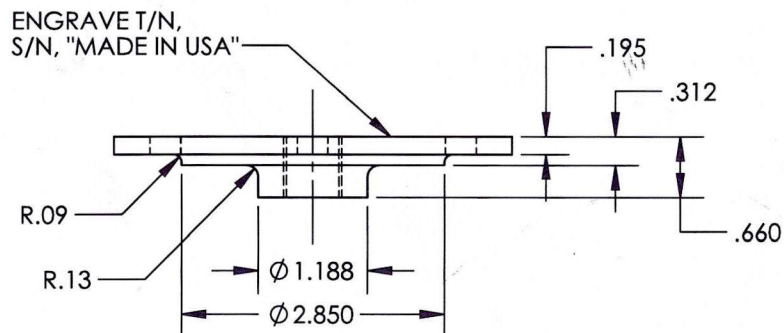
120 QC 8	2 pcs	6/14/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	B.E 19-06-12
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Outsource - 13 - Zinc Plating	2 pcs	6/14/19		GRO002-VC	2019-06-14
140 Packaging 2-1 - Receive - B4B	2 pcs	6/14/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP JUN 19 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
150 QC 6	2 pcs	6/14/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS
				QC 6 - 40	JUN 19 2019 40
160 Packaging 3-1 - Stock - B4B	2 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	9-89
				Packaging 3 - 2 - B4B	

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	M/L
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
170 QC 21 - SA	2 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21
Part Op 100 - 1-Machine as per folio FC <u>804</u> FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-Deburr Descriptions: 120 - Engrave T/N and/or P/N using MARKTRONIC engraver as per DWG. 130 - Issue P/O; <u>43726</u> -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of Conformity is required 140 - Certificate of Conformity is required					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-HRS-R-5.000	Hot Rolled Steel Round Bar 5.000" Dia.	.1320 ft (.066 ea)	100-NLX 2500SY - 1	<u>345745</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-NLX 2500SY - 1	MT-HRS-R-5.000	0	1	0	
Part Specifications					
Specifications could not be found.					

Plex 5/6/19 8:18 AM Dart.lajeunesse.marie

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



①

BASE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19-1603 MLC

2019-06-12 350 19-0506

 RED BARN MACHINE	
TITLE FAN FLANGE EXTRACTOR	
DWG NO. RBEA93-3204-00-1	REV
MAT'L 1018 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: GILBERT APPROVED D Weil HEAT TREAT FINISH CAD PLATE YELLOW SPEC QQ-P-416F, TYPE II, CLASS II USED ON MODEL EUROCOPTER
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 5/6/2011
SHEET 2 OF 4	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

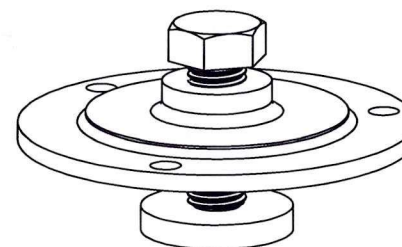
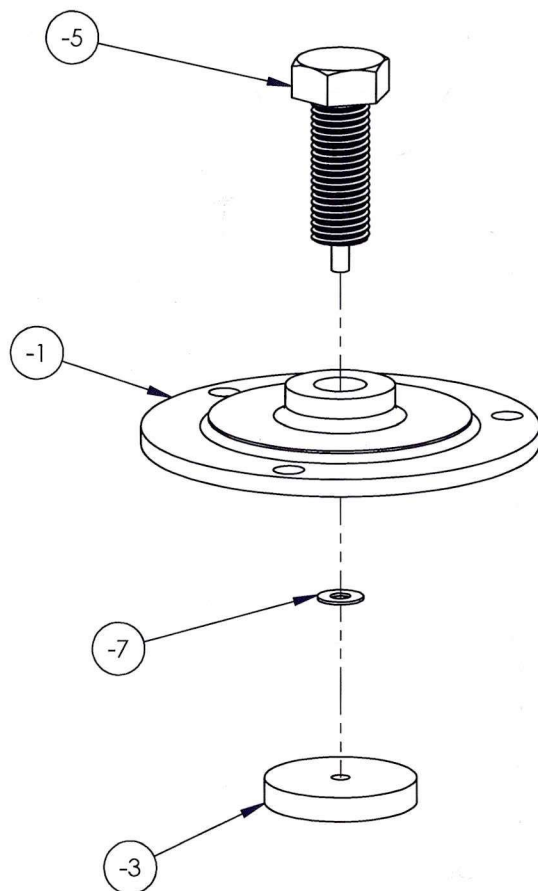
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



NOTE:

1. THREAD -5 INTO -1 THEN, PLACE -3 AND -7 ONTO -5, PEEN END OF -5, ENSURING -3 ROTATES FREELY.
2. REF. OLD RB T/N: RBEA93-3204-00.

 RED BARN MACHINE	
TITLE FAN FLANGE EXTRACTOR	
DWG NO. RBE350A93-3204-00	REV
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER
SCALE 1:2	DATE 5/6/2011
SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	1018	Ø4-3/8 X 3/4	2
			-3	1	DISK	6061	Ø1-3/4 X 5/16	3
			-5	1	HEX HEAD CAP SCREW	STEEL	M16 X 50mm MCMaster-CARR #91180A876 (MODIFIED)	4
		B/O	-7	1	WASHER	STEEL	#10 MCMaster-CARR #91083A011	14



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043726



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043726

PO Date: 6/14/19

Due Date: 6/21/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-17

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194969	RBT18539-3	Pin (Modified B/O) -Issue P/O ; _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; Steel -Certificate of Conformity is required	Firmed	-	6/21/19	4 pcs	0 pcs	4 pcs	\$20.25/pcs	\$81.00
				X4			JUN 19 2019			DP	
2	195116	RBE350A93-3232-00-4	Seal Ring -Issue P/O ; _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1144 -Certificate of Conformity is required	Firmed	-	6/21/19	6 pcs	0 pcs	6 pcs	\$10.00/pcs	\$60.00
				X6			JUN 19 2019			DP	
3	194603	RBE350A93-3204-00-1	Base -Issue P/O ; _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of Conformity is required	Firmed	-	6/21/19	3 pcs	0 pcs	3 pcs	\$10.00/pcs	\$30.00
				X3			JUN 19 2019			DP	

DAS
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9-39



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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043726



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	190332	RBE105-14181W4-15	Base -Issue P/O ; -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; O1 -Certificate of Conformity is required	Firmed	-	6/21/19	6 pcs	0 pcs	6 pcs	\$9.00/pcs	\$54.00
Grand Total:											\$225.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/17/19 3:39 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020063-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

020063- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
18-Jun-2019		SVETLANA DORZHIYEVA		POHB043726				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT18539-3 Rev.	RBT18539-3 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 T1 SC2 STRIP ZINC THEN PLATING	ZINC CH	4	4	0	0	0
2	RBE350A93-3232-00-4 Rev.	RBE350A93-3232-00-4 01 -ZINC-YELLOW TRI ASTM [ZINC-YELLOW TRIVALENT ASTM] B633 T2 SC2	ZINC CH	6	6	0	0	0
3	RBE350A93-3204-00-1 Rev.	RBE350A93-3204-00-1 01 -ZINC-YELLOW TRI ASTM [ZINC-YELLOW TRIVALENT ASTM] B633 T2 SC2	ZINC CH	3	3	0	0	0
4	RBE105-14181W4-15 Rev.	RBE105-14181W4-15 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 T1 SC2	ZINC CH	6	6	0	0	0

RECEIVED

JUN 18 2019

DART AEROSPACE LTD.

**DAS
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9-89**

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.